

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010619**Date Inspected:** 25-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.You Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

**Magnetic Particle Testing:-****BAY#11:-**

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as North Lift 3. The weld designations reviewed are as follows:-

NSTL3-3F/K-21,23,24,25,29,30,31,32,35,36,37,39,41,44,49,50,51,52,54,56,58,98,100,102,104, 106,108 110,111, 112,113, 116,120,121,128,130,131,132.

**IN PROCESS INSPECTION:-****Tower Trial Assembly Area:-****West Shaft Lift1:-**

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WSD1-A423B/H-120 located on Skin D to Base Plate. Welder is identified as 062126.ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA inspector observed the following work in progress:

FCAW welding of weld joint no: WSD1-A423B/H-127 located on Skin A to Base Plate. Welder is identified as 221795.ZPMC CWI is identified as Mr. You Qi Guo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

BAY #10:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-STSA3-1-89M-1-11A located on Strut Plate. Welder is identified as 050289.ZPMC CWI is identified as Mr.Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5b.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: NSTL4-3K/L-134 located on Skin D to Diaphragm. Welder is identified as 068753.ZPMC CWI is identified as Mr. Gang Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P5-F.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: NSD1-SPSA4-20-3A located on Interior Splice Plate. Welder is identified as 040343.ZPMC CWI is identified as Mr. Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

BAY #11:-

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1-STSA3-2-89M-2-3A located on Strut Plate. Welder is identified as 041271.ZPMC CWI is identified as Mrs. Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2212-TC-U5b.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SD1-STSA3-1-109M-1-10A located on Strut Plate. Welder is identified as 040656.ZPMC CWI is identified as Mrs. Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-TC-U5b-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge,Sinevod-13482570045, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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**Inspected By:** Pillai,Pandaram

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer